

# Lumid® GP3150A(W)

Polyamide 6  
LG Chem Ltd.

Message:

Description  
General Purpose  
Applications  
E&E(Rice Coouer Housing)

| General Information                              |                                    |                   |             |
|--------------------------------------------------|------------------------------------|-------------------|-------------|
| Filler / Reinforcement                           | Mineral,15% Filler by Weight       |                   |             |
| Features                                         | General Purpose                    |                   |             |
| Uses                                             | Appliances                         |                   |             |
|                                                  | Electrical/Electronic Applications |                   |             |
|                                                  | Housings                           |                   |             |
| Processing Method                                | Injection Molding                  |                   |             |
| Physical                                         | Nominal Value                      | Unit              | Test Method |
| Specific Gravity                                 | 1.23                               | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow (3.20 mm)               | 0.90 to 1.3                        | %                 | ASTM D955   |
| Water Absorption (Equilibrium)                   | 1.3                                | %                 | ASTM D570   |
| Hardness                                         | Nominal Value                      | Unit              | Test Method |
| Rockwell Hardness (R-Scale)                      | 121                                |                   | ASTM D785   |
| Mechanical                                       | Nominal Value                      | Unit              | Test Method |
| Tensile Elongation <sup>1</sup> (Break, 3.20 mm) | 6.0                                | %                 | ASTM D638   |
| Flexural Modulus <sup>2</sup> (3.20 mm)          | 3630                               | MPa               | ASTM D790   |
| Flexural Strength <sup>3</sup> (Yield, 3.20 mm)  | 108                                | MPa               | ASTM D790   |
| Impact                                           | Nominal Value                      | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.20 mm)              | 39                                 | J/m               | ASTM D256   |
| Thermal                                          | Nominal Value                      | Unit              | Test Method |
| Deflection Temperature Under Load                |                                    |                   | ASTM D648   |
| 0.45 MPa, Unannealed, 6.40 mm                    | 205                                | °C                |             |
| 1.8 MPa, Unannealed, 6.40 mm                     | 95.0                               | °C                |             |
| Peak Melting Temperature                         | 220                                | °C                | ASTM D3418  |
| CLTE - Flow                                      | 5.7E-5                             | cm/cm/°C          | ASTM D696   |
| Electrical                                       | Nominal Value                      | Unit              | Test Method |
| Volume Resistivity (23°C)                        | 1.0E+15                            | ohms · cm         | ASTM D257   |
| Dielectric Strength (23°C, 1.00 mm)              | 22                                 | kV/mm             | ASTM D149   |
| Dielectric Constant (23°C, 1 MHz)                | 4.00                               |                   | ASTM D150   |
| Arc Resistance <sup>4</sup>                      | 185                                | sec               | ASTM D495   |
| Flammability                                     | Nominal Value                      | Unit              | Test Method |

| Flame Rating (0.750 mm)    | HB             | UL 94 |
|----------------------------|----------------|-------|
| Injection                  | Nominal Value  | Unit  |
| Drying Temperature         | 80.0 to 100    | °C    |
| Drying Time                | 4.0 to 5.0     | hr    |
| Suggested Max Moisture     | 0.10           | %     |
| Rear Temperature           | 230 to 255     | °C    |
| Middle Temperature         | 245 to 260     | °C    |
| Front Temperature          | 245 to 270     | °C    |
| Nozzle Temperature         | 250 to 270     | °C    |
| Processing (Melt) Temp     | 250 to 270     | °C    |
| Mold Temperature           | 60.0 to 80.0   | °C    |
| Back Pressure <sup>5</sup> | 10.0 to 30.0   | MPa   |
| Screw Speed                | 60 to 150      | rpm   |
| NOTE                       |                |       |
| 1.                         | 5.0 mm/min     |       |
| 2.                         | 1.3 mm/min     |       |
| 3.                         | 1.3 mm/min     |       |
| 4.                         | 23°C           |       |
| 5.                         | Hydraulic Type |       |

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